

Date: Wednesday, 14/01/2009 3:03:35 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 44763
Estimate Number : 13245
P.O. Number :
This Issue : 14/01/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : 1/1 **Type** : MACHINED PARTS
Previous Run : 44762
Written By : J.M. 08.01.14
Checked & Approved By :
Comment : Est Rev:A 08-03-27 new issue DD verified by:JLM
Drawing Name : SLIDER
Part Number : D36951
Drawing Number : D3695 REVA PRELIM
Project Number : N/A
Drawing Revision : A PRELIM
Material :
Due Date : 21/01/2009 **Qty:** 3 **Um:** Each

Additional Product

PRELIMINARY ISSUE



Job Number:



08.01.4 for ECU H0150LP

Seq. #: **Machine Or Operation:** **Description :**

1.0 M6061T6B2000X01250 6061-T6 Bar 2.00 x 1.25



Comment: Qty.: 0.8400 f(s)/Unit Total : 2.5200 f(s)
 6061-T6 Bar 2.0" x 1.25"
 BATCH: M105411

J.F. 09/01/15

③

2.0 BAND SAW BAND SAW



Comment: Cut blank 9.450" long

J.F. 09/01/15

③

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA739 Rev: AA & Dwg D3695 Rev: C

2-Deburr per dwg D3695\

3-Manually Tap for 10-32 heli coil

J.F. 09/01/15

③

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/15

③

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING APPROVAL

09.01.9

J.L. 09/01/16

Date: Wednesday, 14/01/2009 3:03:35 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDER

Job Number: 44763

Part Number: D36951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

am 09.01.19 (3)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

****mask threaded holes*****

START TIME:

7:10

OVEN TEMPERATURE:

320°

FINISH TIME:

7:40

FL 09/01/20

(3)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-01-20

(X3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

ST 118 MF 09-02-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



POSITIVE RECALL

EFFECTIVE

09-01-19

AUTH

LL

ASED

DATE

09.02.17

mf 09-01-20

DART AEROSPACE LTD		Work Order: 44763
Description: Slider Assembly		Part Number: 3695-1
Inspection Dwg: 3695 Rev: C		Page 1 of 1

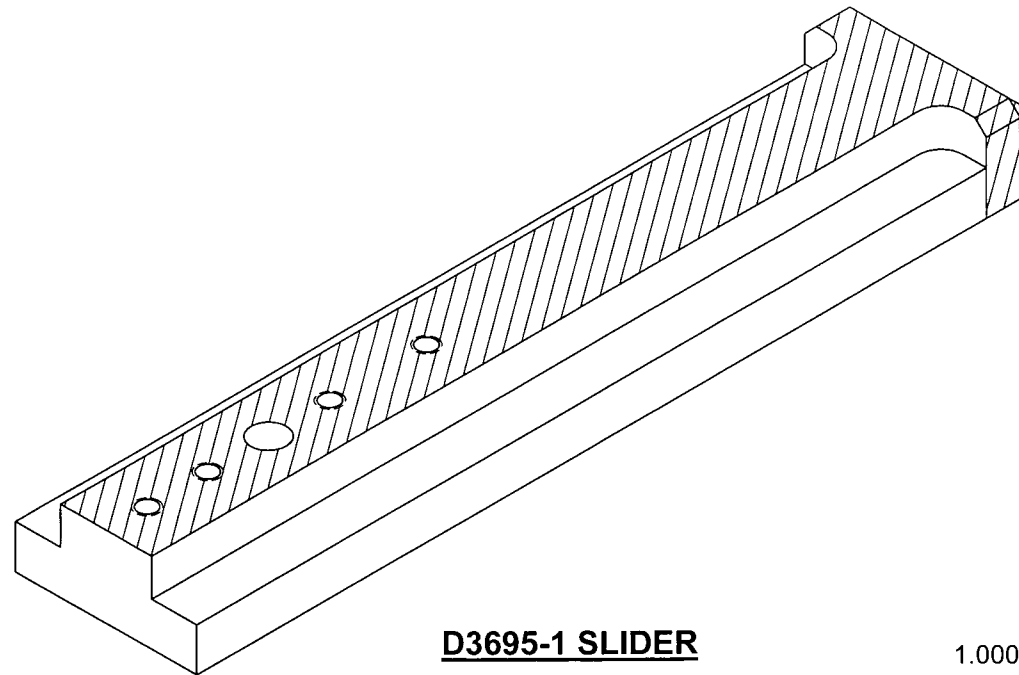
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

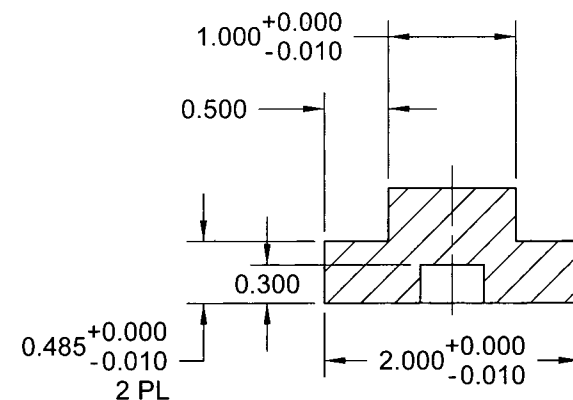
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.750"	+ .005" - .001"	8.750"	✓			
Ø.386"	+ .006" - .001"	Ø.389"	✓			
Ø.203"	+ .005" - .001"	Ø.208"	✓			
.738"	± .010"	.732"	✓			
.500"	± .010"	.500"	✓			
.450"	± .010"	.449"	✓			
2.025"	± .010"	2.025"	✓			
1.075"	± .010"	1.080"	✓			
R.25"	± .030"	R.25"	✓			
1.000"	+ .000" - .010"	.997"	✓			
.500"	± .010"	.495"	✓			
.485"	+ .000" - .010"	.483"	✓			
.300"	± .010"	.299"	✓			
2.000"	+ .000" - .010"	1.995"	✓			
9.25"	± .030"	9.248"	✓			
.900"	± .010"	.898"	✓			
.13" x 45°	± .030"	.145"	✓			
.50"	± .030"	.521"	✓			
Ø.875"	± .010"	Ø.870"	✓			
.310"	± .010"	.299 .311	✓			
4.750"	± .010"	4.758"	✓			
1.060"	± .030"	1.064"	✓			

Measured by: J.F.	Audited by: J.L.	Prototype Approval:	N/A
Date: 09/01/15	Date: 09/01/16	Date:	N/A

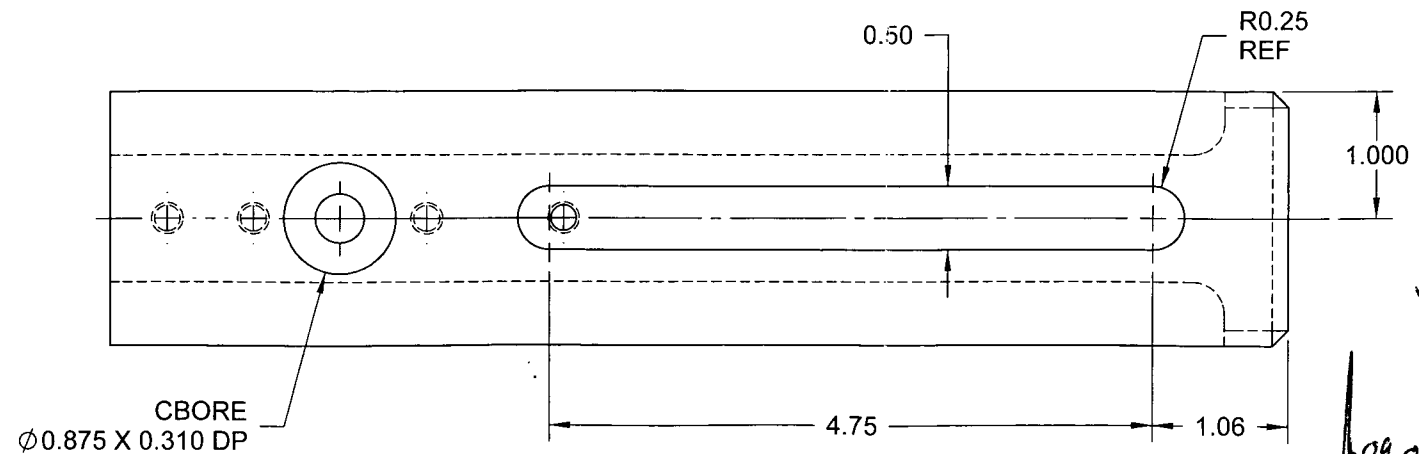
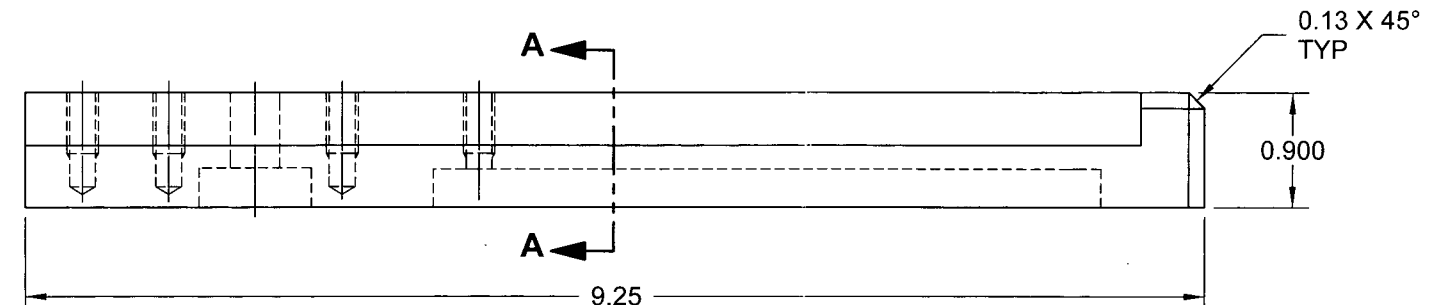
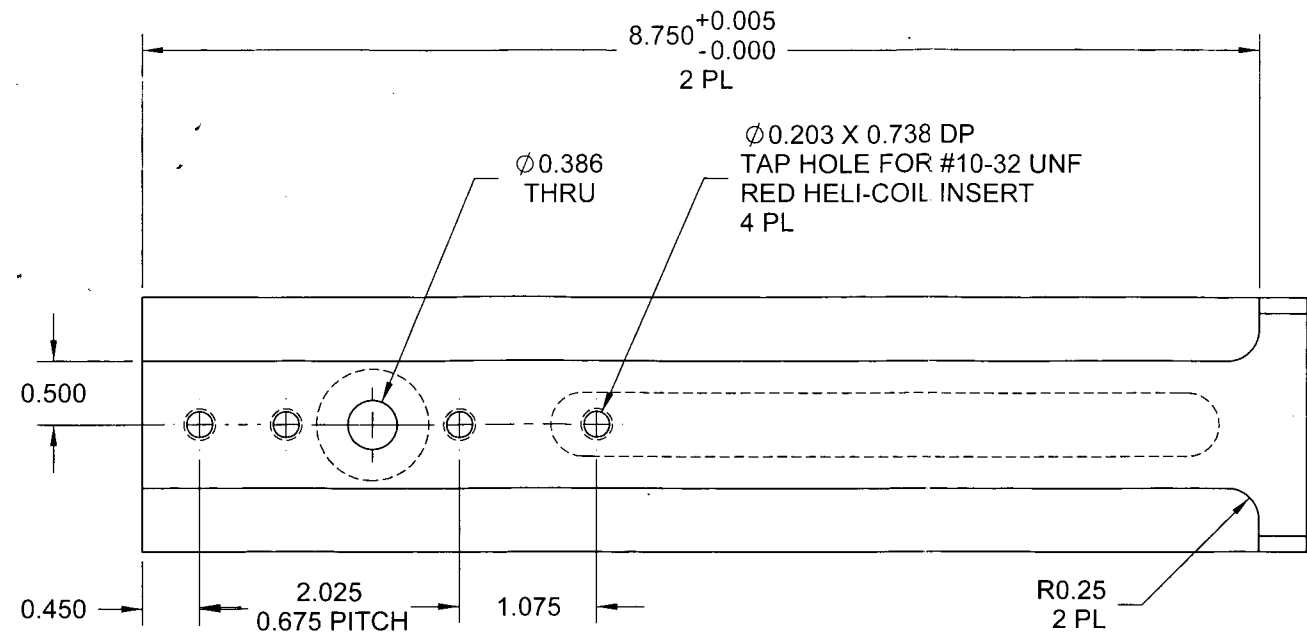
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3695-1 SLIDER



SECTION A-A

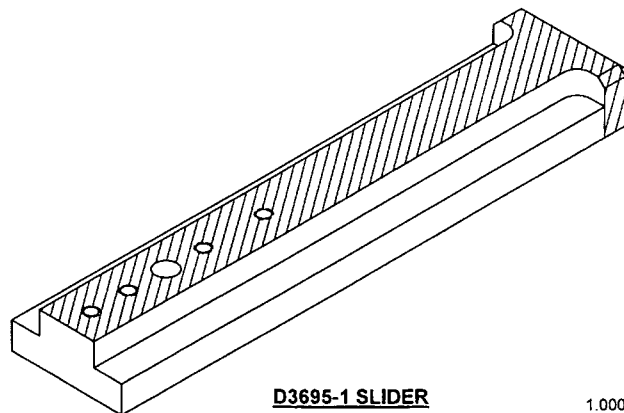


D3695-1 NOTES:

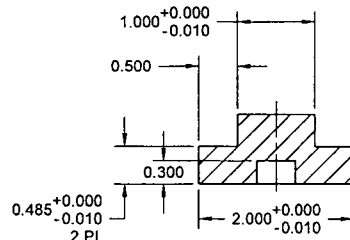
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

PRELIMINARY ISSUE

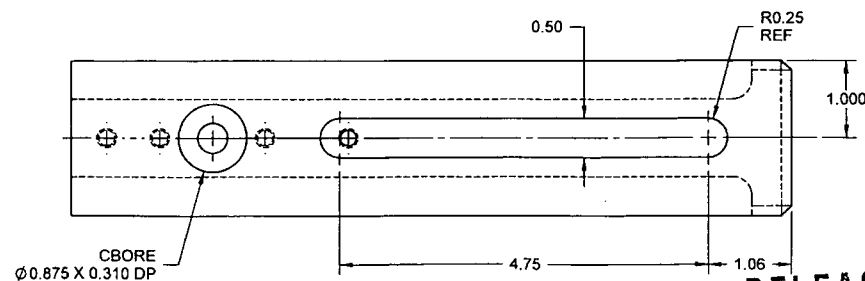
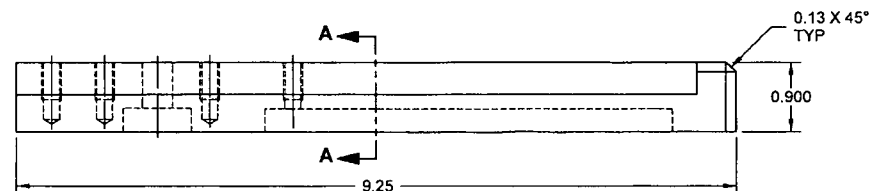
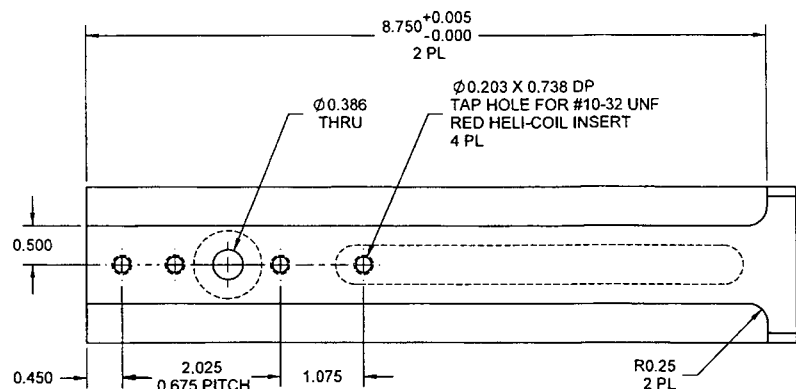
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

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PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

44763

RELEASED
09/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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